



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-633-011
Job Sheet 183561



Part No: D205-633-011

Job Qty: 2 ea

Part Name: Heli-Access-Step™ - High Gear, Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/20/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 17 IPP Rev:F 02.07.11 Reformat; Removed D3010 RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Stores/Pkg-1	88 00 2AS	OCT 01 2018
110	Packaging	2 pcs	10/12/18	10/12/18	0.00	0.00	Packaging1-2	5	OCT 15 2018
120	QC	2 pcs	10/12/18	10/12/18	0.00	0.00	QC4	89 00 9-89	9-89 69 DAS
130	Packaging	2 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3-1	89 00 9-89	9-89 69 DAS
135	DC	2 pcs	10/12/18	10/12/18	0.00	0.00	DC	21	21 9-89 69 DAS
140	QC21-FG	2 Ea	10/12/18	10/12/18	0.00	0.00	QC21	21 9-89	OCT 15 2018

Part Op 130 - Identify and pack for shipping as per PPP D205-633-011 Location:FG082
Descriptions: 135 - Photocopy bluefile & type labels per PPP205-633-011 CHG001

21
DAS 9-89
21
9-89
OCT 15 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	5094583
AN4-5A	Bolt	4 Ea (2 ea)	90-Start up Operation	5089315
AN4-6A	Bolt	4 Ea (2 ea)	90-Start up Operation	5089455
AN4-7A	Bolt	4 Ea (2 ea)	90-Start up Operation	5082520
AN5-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	5056344
AN5-6A	Bolt	2 Ea (1 ea)	90-Start up Operation	5103251
D2021-101	Eyebolt	2 Ea (1 ea)	90-Start up Operation	5091964
D2022-101	Spacer	4 Ea (2 ea)	90-Start up Operation	5106652
D2022-103	Spacer	4 Ea (2 ea)	90-Start up Operation	5109876
D2562-001	Strut 19.68"	2 Ea (1 ea)	90-Start up Operation	5104752
D2565-101	Strut	2 Ea (1 ea)	90-Start up Operation	510945X1 5111089 X1
D2565-103	Strut	2 Ea (1 ea)	90-Start up Operation	5109428 X1 511101X1
D2565-105	Strut	2 Ea (1 ea)	90-Start up Operation	5109448 X1 5111119 X1
D2565-107	Strut	2 Ea (1 ea)	90-Start up Operation	5111873
D2565-109	Strut	2 Ea (1 ea)	90-Start up Operation	5109531 X1 5111239 X1
D2565-111	Strut	2 Ea (1 ea)	90-Start up Operation	5111326
MS21042L4	Nut	16 Ea (8 ea)	90-Start up Operation	5091594
MS21042L5	Nut	4 Ea (2 ea)	90-Start up Operation	5083541
NAS1149D0463J	Washer	30 Ea (15 ea)	90-Start up Operation	5109426 X1 - 5099299 X22
NAS1149D0563J	Washer	8 Ea (4 ea)	90-Start up Operation	5093773
D2563	Step Weldment Assembly	2 Ea (1 ea)	110-Packaging	5114444

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																									
Part No. _____		Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																							
NCR No. _____		Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																							
		Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																							
		Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐																																								
Date: _____	Step #: _____	QTY Effective : _____				MRB (QSI042) Approval																																							
Description of Work Order Deviation		Disposition				Completed By																																							
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S114924 Part: D205-633-011 Job No: 183561 Serial No/Batch: S114924 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH96-57 Issue BarFAA-STC SR00592NY 03/08/01, FAA STI						Lead hand / Supervisor Approval Verification																																							
						QC / QA Coordinator Approval																																							
FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Temperature/Cure</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Set-up</td> <td>☐ Folio/Program</td> <td>☐ Outside Dimensions</td> </tr> <tr> <td>☐ Centre Not Concentric</td> <td>☐ BOM/Route</td> <td>☐ Grain</td> <td>☐ Over/Under tolerance</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Part Incorrect</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave</td> <td>☐ Inspection Incomplete/Unqualified</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Cuffs</td> <td>☐ Contamination</td> <td>☐ Out of Sequence</td> <td>☐ Part Moved</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ Countersink</td> <td>☐ Off-set</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> <td>☐ Mislabeled</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> <td>☐ Fit/Function</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Misaligned/off center</td> <td>☐ Turning Sequence</td> </tr> </table>		☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
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OTHER : _____																																													

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-14A	2	531	0
	AN4-5A	4	193	0
	AN4-6A	4	1,147	0
	AN4-7A	4	214	0
	AN5-14A	2	66	0
	AN5-6A	2	94	0
	D2021-101	2	24	0
	D2022-101	4	15	0
	D2022-103	4	17	0
	D2562-001	2	0	0
	D2565-101	2	7	0
	D2565-103	2	7	0
	D2565-105	2	7	0
	D2565-107	2	11	0
	D2565-109	2	7	0
	D2565-111	2	10	0
	MS21042L4	16	3,874	0
	MS21042L5	4	836	0
	NAS1149D0463J	30	6,776	0
	NAS1149D0563J	8	1,580	0
110-Packaging	D2563	2	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

5.0 PARTS LISTS

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	3	3	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: C

Date: 13.12.13

Change Record

PAGE 1 OF 1

Part Number: D205-633-011/-017

Description: HELI-ACCESS STEP, HIGH GEAR / STANDARD LOW GEAR

[illegible]